

Work Order ID 103712

103712

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June-25-13 10:57:38 AM

Item ID: D3290-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Exterior Window for -111
 Start Date: 6/25/13 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 6/25/13 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3290	Rev C								
150	Pick Kit	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160		0.00							
160	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3290								
	Clean D3290-041 and place in plastic wrap								
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									

143/4/25 (9)

74. (DAS 07 2-89) 13/06/26

27 13626

4

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: ST213(3x)	0.00							
180									
Packaging	Memo								
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

Handwritten notes:
 4x
 11/11/13-06-26
 13/6/27
 W1 306-26

Picklist Print

June-25-13 10:57:37 AM

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Work Order ID: 103712
 Parent Item: D3290-041
 Parent Item Name: Replacement Exterior Window for -111

Start Date: 6/25/13

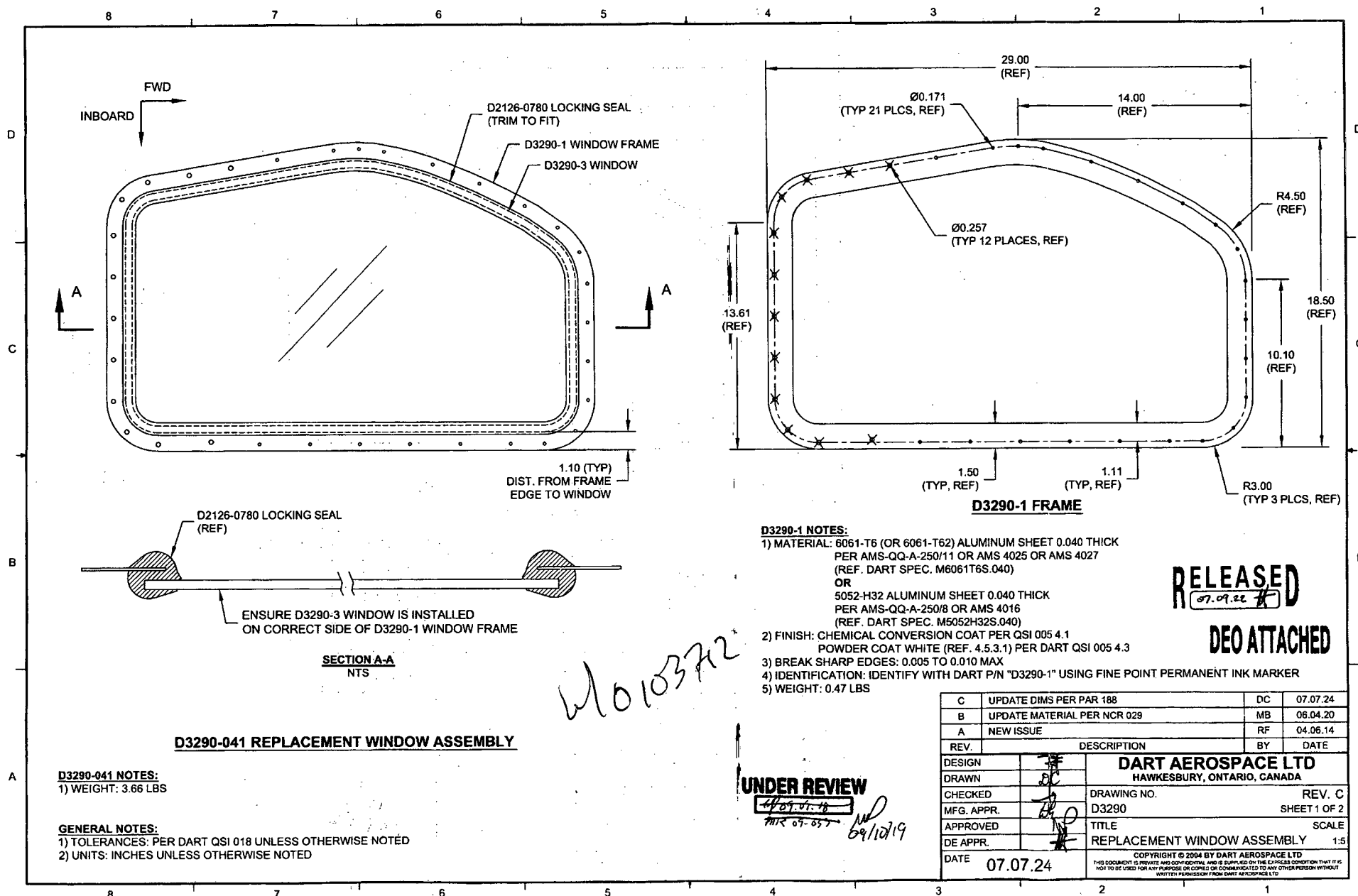
Required Date: 6/25/13

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP B05.05.25 Added Step 11KJ/JLM
 IPP C06.05.09 Ecn 798 EC
 IPP Rev:D Now on Waterjet 06-06-16 JLM
 IPP rev E rev C dwg 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3290-1 Frame		Manufactured	No			150	Each	6.0000	1	5			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST213		2							
				73721		2							
				ST218		4							
				99618		4				99618	4		
D2126 Seal		Manufactured	No			150	f	145.3308	6.5	32.5			
(D2126-0780) cut qty (1) at 78.00" as per dwg ***per kit***				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST405		145.33079							
				57106		4							
				68336		2.44679							
				89058		138.884				89058			
D3290-3 Window		Manufactured	No			150	Each	5.0000	1	5			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST214A		5							
				93792		1							
				99720		4				99720	4		

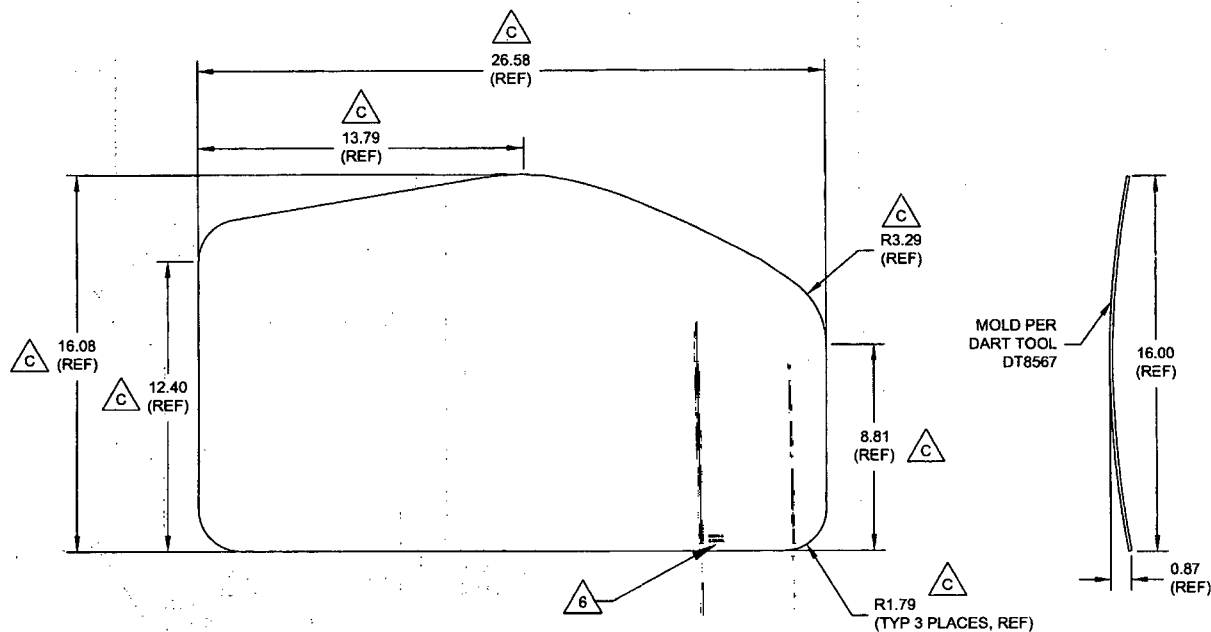


RELEASED
 07.07.24
 DEO ATTACHED

UNDER REVIEW

07.07.18
 07-057
 6/10/19

W10103712



D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

UNDER REVIEW

DEO ATTACHED

RELEASED

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3290 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY 1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>js</i>	MFG. APPR. <i>E</i>	APPROVED <i>MP</i>	DE APPR. <i>MP</i>			
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21	DATE 09/09/21			

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009-10-09
MP

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